

Date: Monday, 9/18/2006 2:29:46 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOUBLER
Job Number	: 28641		
Estimate Number	: 10775		
P.O. Number	: N/A	Part Number	: D32081
This Issue	: 9/18/2006	Drawing Number	: D3208 REV A
Prsh Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: A
Previous Run	: N/A	Material	: N/A
Written By	:	Due Date	: 9/30/2006
Checked & Approved By	: <u>DK 06.09.19</u>	Qty:	12
Comment	: Est: B04.05.28 Material changed for Step 4KJ/JLM		

## Additional Product

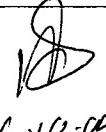
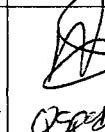
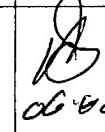
Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S040	2024-T3 .040 sheet  Comment: Qty.: 0.1727 sf(s)/Unit Total : 2.0727 sf(s) Material: 2024-T3 (QQ-A-250/4) 0.040" thick (M2024T3S.040) Note: To be made in multiples of 10 Batch: <u>M19295</u>
2.0	SHEAR	SHEAR  Comment: SHEAR Cut blank: 4.038" X 5.340" grain along 4.038" Identify for D3208-1
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1  Comment: SMALL & MEDIUM FAB RESOURCE 1 Drill and Fillet D3208-1 corner as per Dwg D3208 Identify as D3208-1
4.0	BRAKE NC	NC BRAKE  Comment: NC BRAKE Deburr D3208-1 Form D3208-1 as per Dwg D3208 Polish any marks on part within 01. of Dwg D3208

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/10/04  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/10/04	4	1 part was out of Tolerance	 06/10/04	Scrap & destroy	SN 06/10/04	 06/10/04	 06/10/04	 06/10/04

NOTE: Date & initial all entries

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Drawing Name: DOUBLER

Job Number: 28641

Part Number: D32081

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



*JAD 10-10-06 11*



Comment: INSPECT WORK TO CURRENT STEP

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*SAD 0840:12 11*

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

*B 06/10/18 11*

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST415*

*L306/10/18 11*

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*10 06/10/18*

Job Completion



*11 06/10/18*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

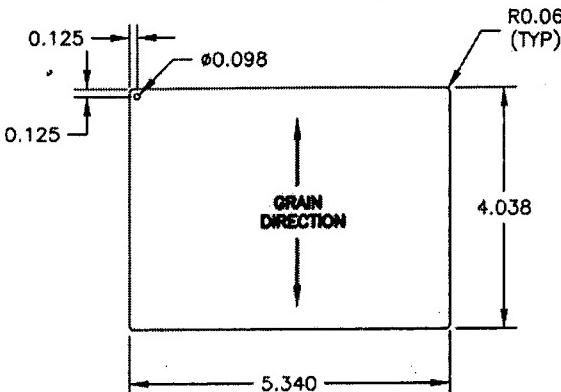
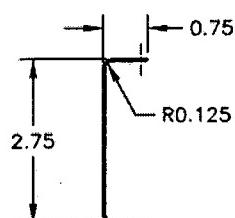
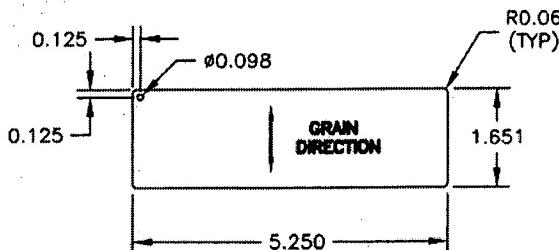
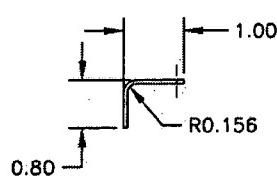
NOTE: Date & initial all entries

**DART**

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3208	REV. A SHEET 1 OF 3
DATE 04.01.27		TITLE DOUBLER	SCALE 1:3

**RELEASED**04.04.05 *[initials]*

A	04.01.27	NEW ISSUE
A1	# 3F 04.05.25	CHANGE DIM ; NOTE 3) CHANGE

2 D3208-1 DOUBLER  
FLAT PATTERND3208-1 DOUBLER  
BEND DETAIL3 D3208-3 PEDAL MOUNT ANGLE  
FLAT PATTERND3208-3 PEDAL MOUNT ANGLE  
BEND DETAIL**NOTES:**

- 1) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040" THICK (M2024T3S.040)
- 3) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063" THICK (M2024T3S.063)
- 4) MATERIAL: 2024-T3 (QQ-A-250/4) 0.080" THICK (M2024T3S.080)
- 5) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES
- 8) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063" THICK (M6061T6S.063)

*[initials]*

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WORK ORDER

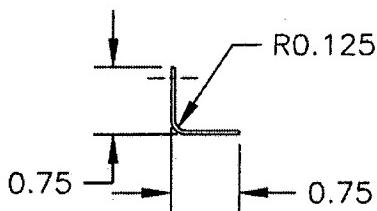
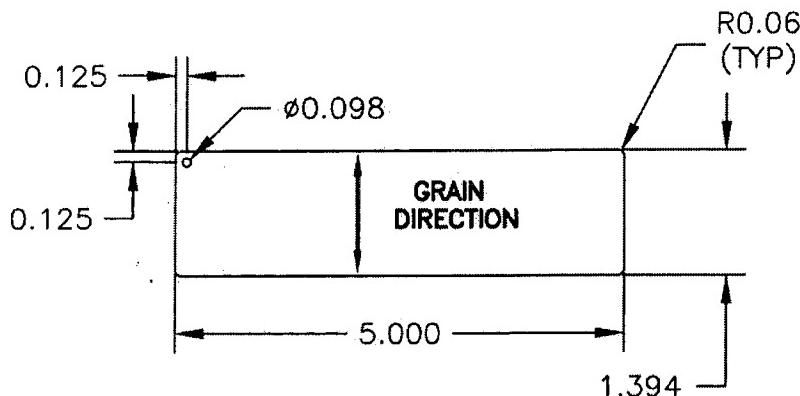
NO. 28641

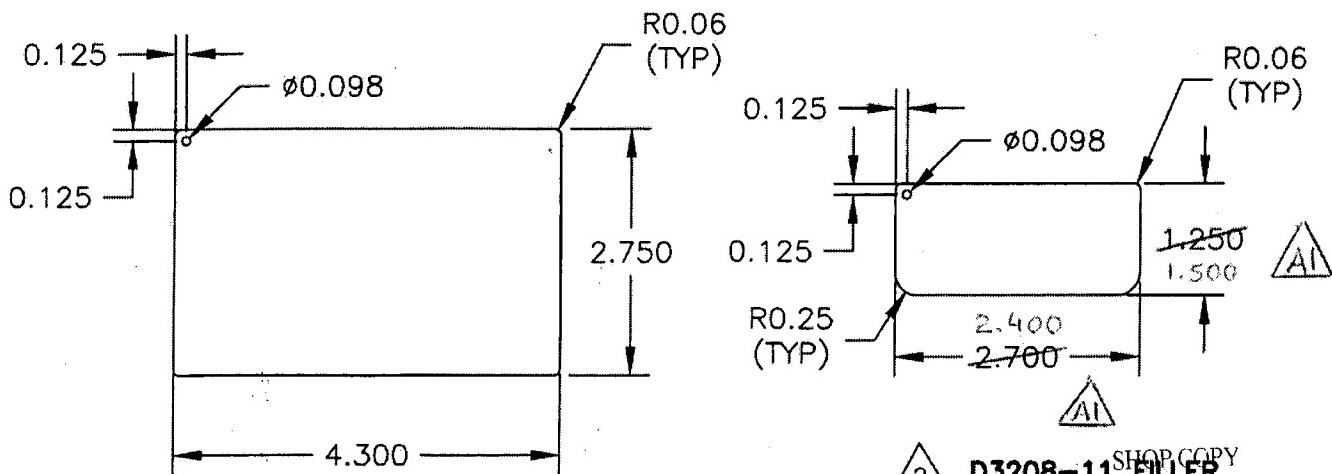
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DATE 04.01.27		TITLE DOUBLER	SCALE 1:2

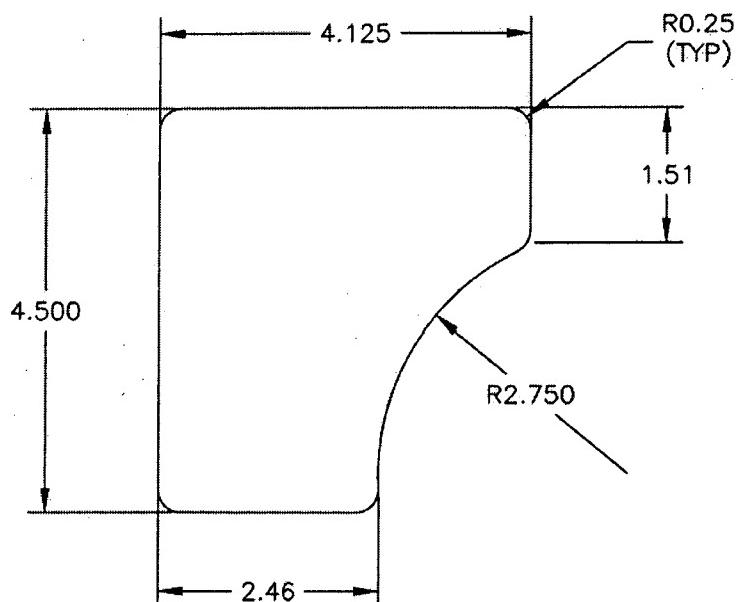
**RELEASED**  
 04.04.05 *[Signature]*

D3208-5 MOUNT ANGLE  
BEND DETAIL

D3208-5 MOUNT ANGLE  
FLAT PATTERN

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NO. *28641*

D3208-7 FILLER

**DART**

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DATE 04.01.27		TITLE DOUBLER	SCALE 1:2

**RELEASED**  
04.04.05 C/P**D3208-9 DOUBLER**

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